

Work Order ID 69930

Tuesday, May 24, 2011 2:23:58 PM



Page 1

Item ID: D3407-3

Accept



Setup Start



Revision ID:

Item Name: Stem

Stop



Start Date: 5/24/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:



Date: 110524

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3407	Rev E

100



DOOSAN LATHE

Doosan

Doosan Lathe

Memo

0.00

RP 11-6-2

20 6

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

RP 11-6-2

20 6

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

SL 11612

20 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location:

BRICL.

0.00

140



QC

Quality Control

QC2I- Final Inspection - Work Order Release

0.00

Memo

0.00

MF

11-06-03

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Picklist Print

Page 1

Tuesday, May 24, 2011 2:24:04 PM

Work Order ID: 69930



Parent Item: D3407-3



Parent Item Name: Stem

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 05.10.18 New issue KJ/EC

IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD

IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174R0.750 17-4 round bar .750		Purchased		No		100	f	36.0000	0.366	6.164211		RE	11 . 6 . 2

Location	Loc Qty	Loc Code
MAT030 117683	36 36	7-475

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DART AEROSPACE LTD	Work Order:	169930
Description: Stem	Part Number:	D3407-3
Inspection Dwg: D3407 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	.063	/		RQ .02	
1/4-28 UNF	Max: 0.2668 Min: 0.2635	.265	/		RQ .06	
Major Ø	Max: 0.249 Min: 0.2425	.246	/		1.	
Ø0.625	+/-0.010	.625	/		RQ .02	
Ø0.363	+/-0.010	.363	/			
Ø0.750	+/-0.010	.749	/			
R0.100	+/-0.010	.100	/			
0.470	+/-0.010	.470	/			
0.250	+/-0.010	.248	/			
2.555	+/-0.010	2.550	/			
3.305	+0.000/-0.010	3.297	/			
4.325	+/-0.010	4.324	/			
0.150	+/-0.010	.156	/			
0.550	+/-0.010	.555	/			
0.625	+/-0.010	.622	/			
0.250	+0.010/-0.000	.252	/			

Measured by:	ZP	Audited by:	DA	Prototype Approval:	N/A
Date:	11.6.2	Date:	10/6/2	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue	KJ/JLM	
B	07.09.26	Tolerances revised	KJ/EC	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD	JK

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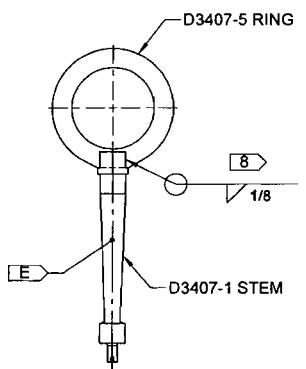
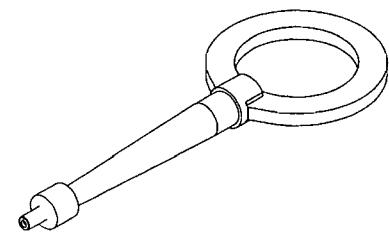
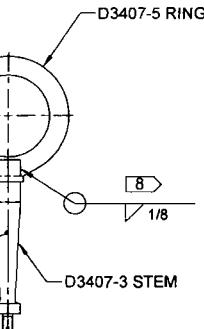
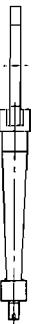
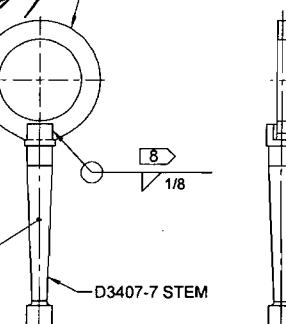
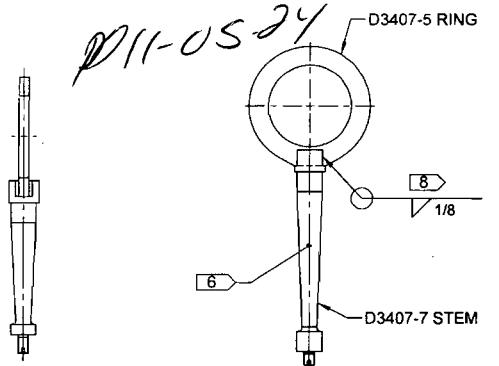
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

E

QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
1	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69930

D3407-041 TOW RINGD3407-043 TOW RINGD3407-045 TOW RING ERELEASED
08-07-2005

A NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER E
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

REV.	DESCRIPTION	BY	DATE
DESIGN	1P		
DRAWN	1P		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.23		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. D3407 REV. E
SHEET 1 OF 5

TITLE: TOW RING
SCALE: NTS

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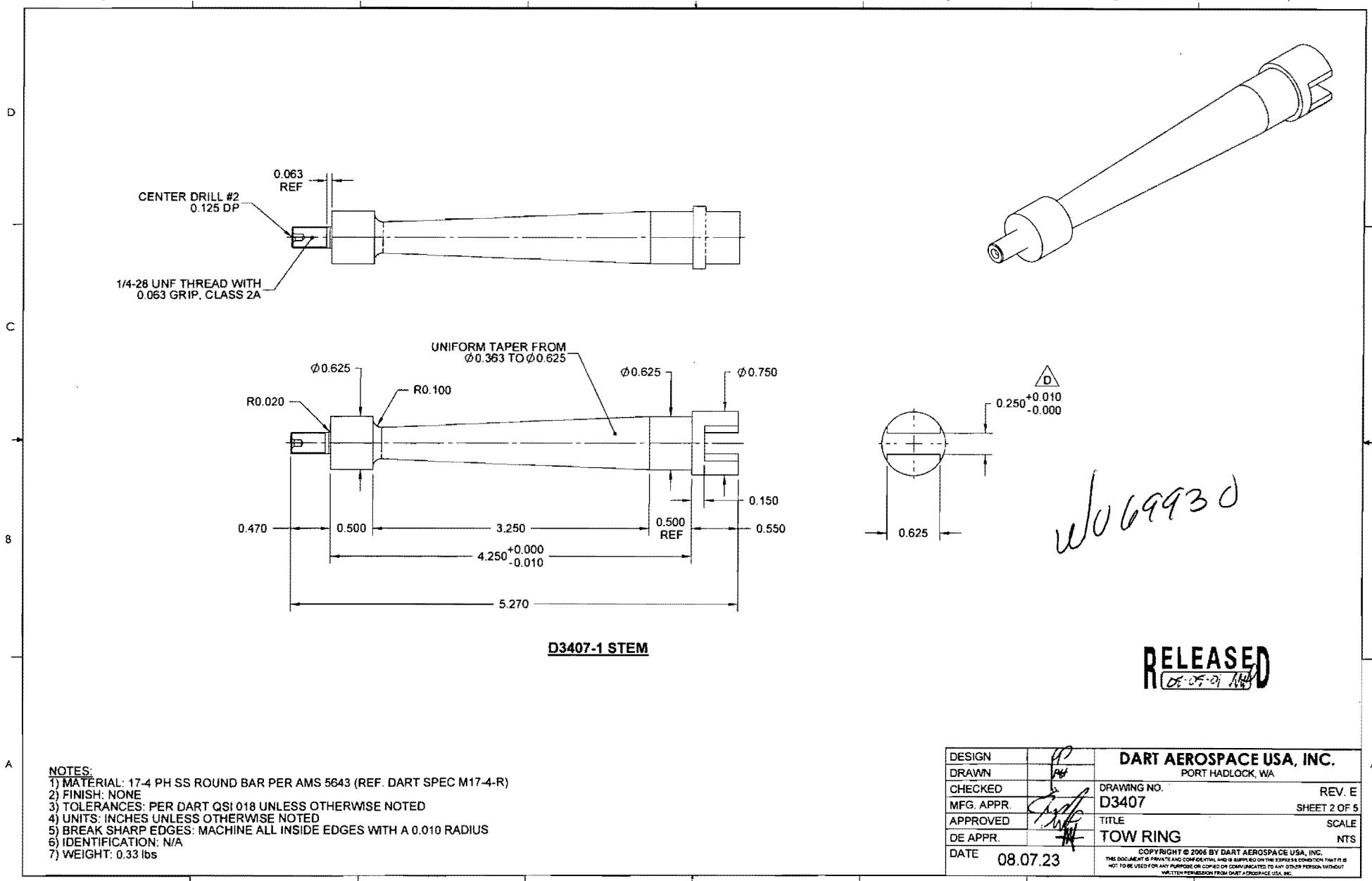
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8 7 6 5 4 3 2 1



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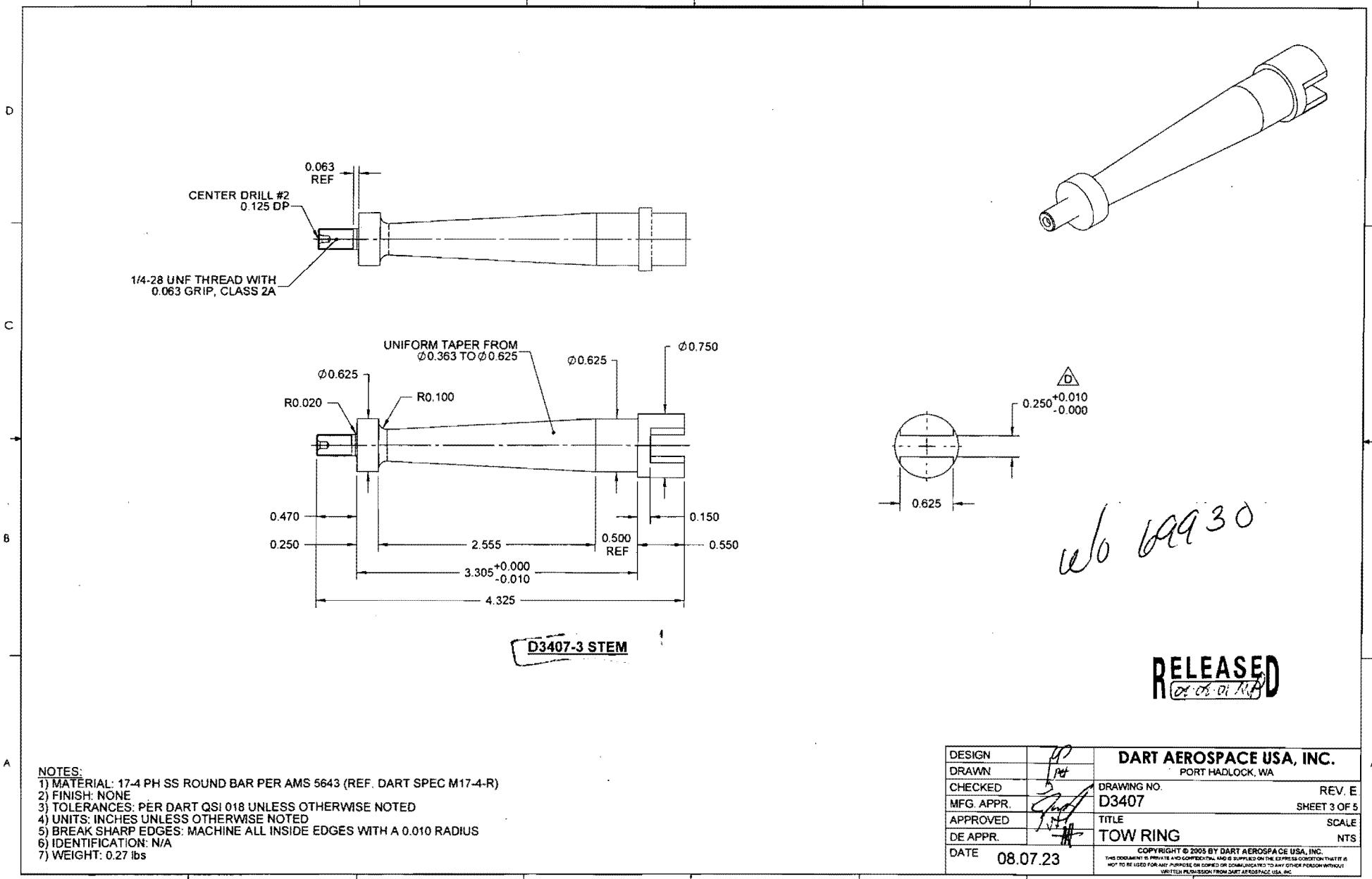
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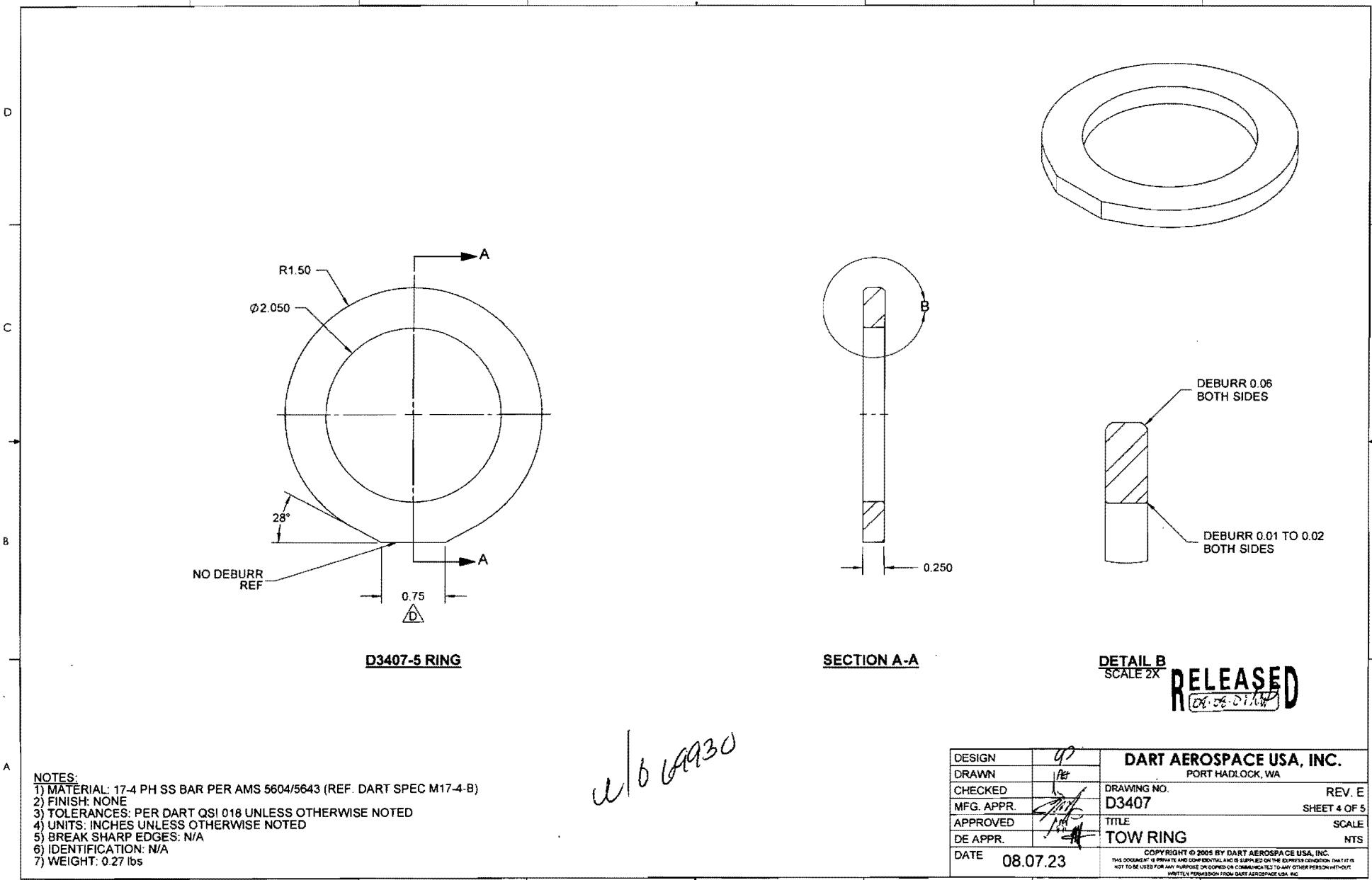
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8

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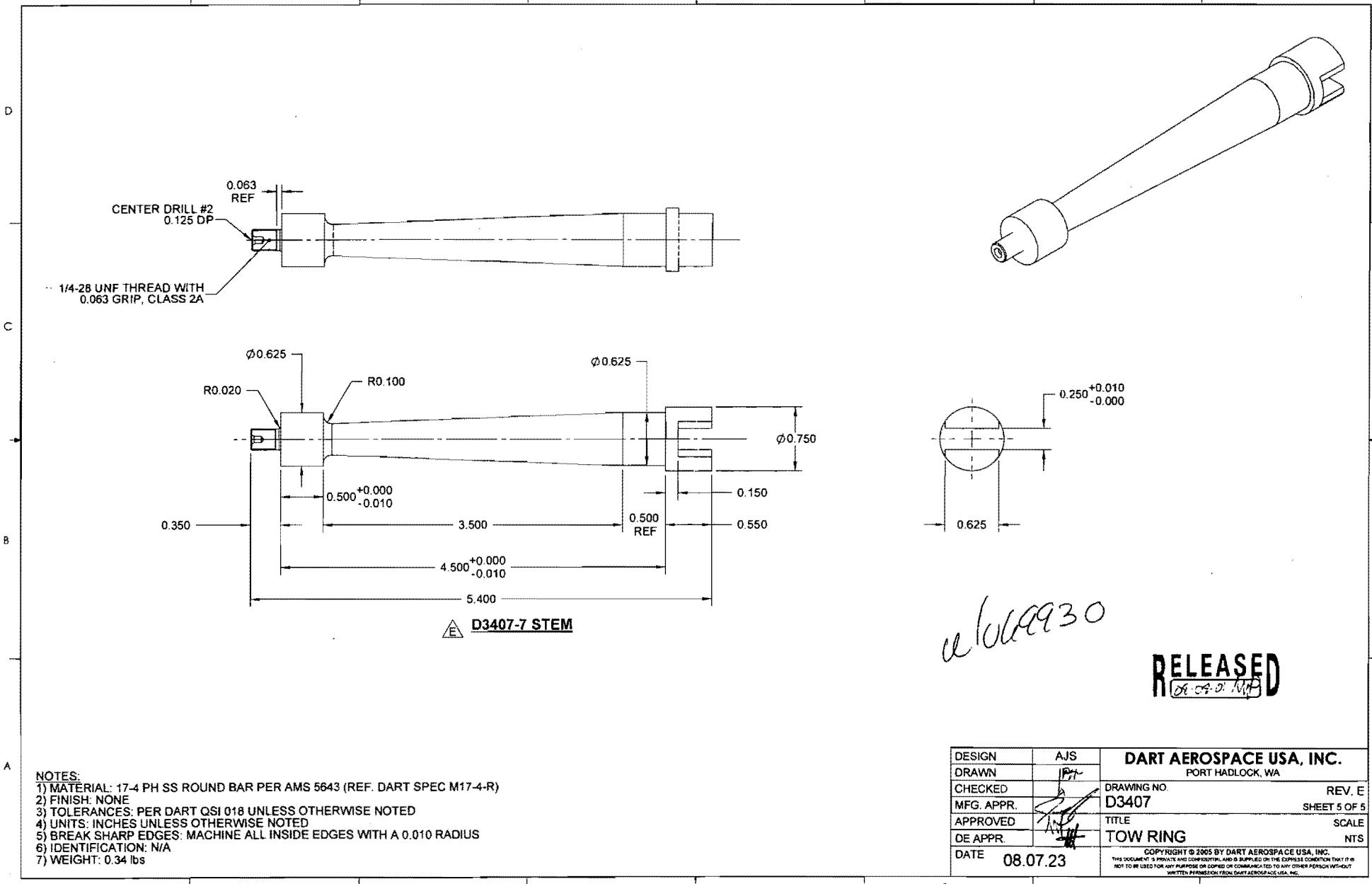
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